Quality Control

Work Order January-23-14 1:		1842		*111	1842*						Page 1
Revision ID:	03492-11			Accept	*N900	<u> </u>	100)* s	etup Sta	171	S1*
Item Name: P	lug								310	_h *//	S2*
	/23/14	Start Qty: 24.00	*24*		Cust Item I	D:					
Required Date: 2	/06/14	Req'd Qty: 24.00	*24*		Customer:						
Reference:					,,,		_	10	Sto		
Approvals:	Process Pla	n: MLJ	Date: 14-01-23	Tooling:	Da	ıte:		K	kun Sta	~I/J	R1*
	QC:	, , ,	Date:	SPC (Y/N):	Da	ıte:			Sto	_b *N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									
D3492	E			•							
100				0.00							
100		Hardinge CNC LATHE S	MALL					24	_ Õ		JFC 2014-01-30
Hardinge		Memo		0.00							
Hardinge CNC Lathe	Small	1-Turn as pe Dwg Rev: Folio Rev:	r Folio FA714 & Dwg D349 <u>Ē</u> AA	92							
110		QC2- Inspect parts off ma	achine FAI/FAIB	0.00							
*11 0 *								24	Ø		JFC 2014-0-30
QC		Memo		0.00					- V		<u> </u>
Quality Control											
		<u>.</u> .									
120 *120*		QC8- Inspect parts - seco	and check	0.00	141-1-3	P)		1 (/	\int_{Γ}		
QC		Memo		0.00	•			-	4)		

DQA:			Date:											•	
•						WORK ORDER NON	-C(ONFO	RMANCE / U	PDATE					
QA Closed:			Date:						•		W	ork Order up	date only	\neg	ALNOOFAGE
						DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Work Ord	er: .					<u> </u>	,					, 1	_	_	
Daw 1						Rework			Skid-tube	Crosstube			Water Jet	_	Engineering
Part I	vo.					Scrap	ł		Machining	Small Fab	${}$	1	d. Eng. Coor.		Quality
NCR I	VI.O.					Use-as-is Suspected Unapproved	1	Inern	noforming Large Fab	Finishing Composite		Kec/Stol	e/Packaging		Other
IVCIVI	٧٠.					Suspected Onapproved	J		raige rab	Composite	<u> </u>	}	Supplier		
Root		-			Desc	ription of work order update		Initial	Ac	tion		Sign &		П	
Cause		Date	Step	Qty		or non-conformance	Cr	nief Eng	Desc	ription		Date	Verification	١	QC Inspector
Design										•					·
Doc/Data															
Equip/Tooling							ļ							ŀ	
Handling/Pre					İ		1								
Material					<u> </u>		İ							-	
Operator	Ш														
Offset/Setup	Ш								İ						
Process	Ш														
Supplier														İ	
Training															
Transport															
Unapproved							<u> </u>							$oldsymbol{ol}}}}}}}}}}}}}}}}}}}}}$	
							FA	ULT CA	FEGORY				•		
Landi					_	General	_	٦.			_	1	-		
Į.		Bending				Bend	L	4	Program			Outside Dim		-	Pressure/Forced
		Centre No	ot Concer	itric		BOM/Route	$ldsymbol{le}}}}}}$	Grain				Over/Under		${oldsymbol{\sqcup}}$	Set-up
	-	Cracks			_	Broken/Damage/Defect	$ldsymbol{le}}}}}}$	Hardwa				Part Incorred	ાં [${ m \square}$	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		4	ion Incomplete/U	·		Part Lost/Mi	ssing		Weld
		Cuffs				Contamination		-1	tions Incomplete/	Unclear		Part Moved	L]	Wrong Stock Pulled
	_	Crushing			<u> </u>	Countersink	L	4	ned/off center		<u> </u>	Positioned V			
	-	Heat Trea				Cut Too Short		Mislabe			<u> </u>	Power Loss/	Surge [Other
	-	Inspection	-	Tube	<u> </u>	Drawing		Misread							
	<u> </u>	Marks/Ch			\perp	Drill Holes	<u></u>	Off-set							
	<u> </u>	Turning S			<u> </u>	Finish		-1	Calibration						
ĺ	l	Wave/Tw	ist in Tub	e		Fit/Function	1	Out of	Sequence						

W	ork	Orde	r ID	111842
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111842

Page 2

January-23-14 1:18:12 PM

Item	m:	D3492-11
illi	w.	レンサンム・エエ

Required Date: 2/06/14

Accept

N900040100

Setup Start

Revision ID:

Start Date:

Item Name: Plug

Start Oty: 24.00 1/23/14

Reg'd Oty: 24.00

24 *94*

Cust Item ID:

Customer:

Reference:

Α	ppro	vole	
A	DDIO	vais	•

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Stop

Sequence ID/ **Work Center ID** **Operation Description**

Chemical Conversion Coat per QSI005 4.1

Set Up/ **Run Hours** **Tool ID**

Tool # Plan Code

Accept Qty

Reject Qty

Reject

Insp. Number Stamp

150

150

160

HandFinish Hand Finishing

Memo

0.00

0.00

24-76 14-1-31

160 Powdercoat

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

Memo

Powder Coating

(Flat End Only) START TIME:

OVEN TEMPERATU

FINISH TIME:

0.00

0.00

170

170 OC

Memo

QC3- Inspect Part Finish

0.00

0.00

24 \$ 14.Q4H

Quality Control

DAS 9-89

DQA: Date:						TRAG Z										
						WORK ORDER NON-	-CC	ONFO	RMANCE / L				-		AEROSPACE	
QA Closed:			Date:								Wor	k Order up	date only			
Work Orde	er:				:	DISPOSITION				AGAINST [DEPA	ARTMENT	PROCESS			
	•	-121				Rework			Skid-tube	Crosstube			Water Jet		Engineering	
Part N	lo.					Scrap			Machining	Small Fab		Proc	d. Eng. Coor.		Quality	
						Use-as-is		Thern	noforming	Finishing		Rec/Stor	e/Packaging		Other	
NCR N	Ю.					Suspected Unapproved			Large Fab	Composite			Supplier			
Root					Desci	ription of work order update		nitial	Ac	ction		Sign &	·			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	\perp	Date	Verification	1	QC Inspector	
Design																
Doc/Data																
Equip/Tooling																
Handling/Pre																
Material		,														
Operator		,														
Offset/Setup		. '			İ											
Process																
Supplier																
Training		,							1		-					
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Landi	ng (Sear				General	IA	oei ca								
		Bending				Bend		Folio/F	rogram	. Г	\Box_{α}	outside Dim	ensions [Pressure/Forced	
		Centre No	ot Concer	ntric		BOM/Route	H	Grain		ŀ	_	ver/Under	· · · · · · · · · · · · · · · · · · ·		Set-up	
		Cracks				Broken/Damage/Defect		Hardwa	ire	F	_	art Incorrec	- F		Temperature/Cure	
	-	Crimp/Kir	nk/Ripple	/Wave		Burrs		1	ion Incomplete/U	Jngualified	_	art Lost/Mi	- F		Weld	
	-	Cuffs				Contamination		ı	ions Incomplete	· •		art Moved	F		Wrong Stock Pulled	
:	_	Crushing				Countersink	-	1	ned/off center	F		ositioned W	_		ı •	
	$\overline{}$	Heat Trea	it			Cut Too Short		Mislabe		Ţ		ower Loss/S	·		Other	
		Inspection	n Strip in	Tube		Drawing		Misrea	t	_			- L			
		Marks/Ch				Drill Holes		Off-set			-					
		Turning S	equence			Finish		Out of	Calibration		-					
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence							

Work	0	rd	er	ID	111842)
Ianuan	22	11	1.1	0.12	DM	

111842

Page 3

January-23-14 1:18:12 PM Accept Item ID: D3492-11 *N900040100* Setup Start **Revision ID:** Stop **Item Name:** Plug *24* **Start Qty: 24.00 Start Date:** 1/23/14 **Cust Item ID:** Req'd Qty: 24.00 Required Date: 2/06/14 *94* **Customer:** Reference: Start Run Tooling: **Process Plan:** Date: Date: **Approvals:** Stop Date: SPC (Y/N): QC:____ Date: Plan Sequence ID/ Operation Set Up/ **Tool ID** Tool# Reject Reject Accept Insp. Stamp Qty Number **Description** Code Oty **Work Center ID Run Hours** Identify as per dwg & Stock Location: 173-06 180 0.00 *120* 0.00 Packaging Memo Packaging 190 QC21- Final Inspection - Work Order Release 0.00 MLJ 1402-05 MLJ 1402-05 *100* 0.00 QC Memo Quality Control

DQA:			Date:										
						WORK ORDER NON-	-CC	NFO	RMANCE / UPD	ATE			AEROSPACE
QA Closed:			Date:							Wo	ork Order up	date only	
Work Orde	ır.					DISPOSITION				AGAINST DE	PARTMENT/	PROCESS	
WOIK Olde	٠.					Rework			Skid-tube C	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap				Small Fab	Proc	d. Eng. Coor.	Quality
	•					. Use-as-is			~—	Finishing		e/Packaging	Other
NCR N	lo.					Suspected Unapproved			Large Fab Co	omposite		Supplier	
Root					Desci	ription of work order update	ı	nitial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descripti	on	Date	Verification	QC Inspector
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Doc/Data	_												
Equip/Tooling	_												
Handling/Pre													
Material	_		!										
Operator													
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1						· · · · · · · · · · · · · · · · · · ·	FAL	JLI CA	TEGORY			***	
Landi		l				General Bend		ا دمانه ۱۵	Program		Outside Dim	ione	Pressure/Forced
		Bending Centre No	ot Concor	atric	_	BOM/Route		Grain	rogram		Over/Under	 	Set-up
		Cracks	or concer	ICIIC		Broken/Damage/Defect	-	Hardwa	ara		Part Incorred	—	Temperature/Cure
		Crimp/Kin	k/Rinnle	/\//ave	-	Burrs		4	ion Incomplete/Unqua	alified	Part Lost/Mi		Weld
		Cuffs	ik) Kippie	, wave	┢	Contamination	_	'	tions Incomplete/Uncl		Part Moved		Wrong Stock Pulled
		Crushing			\vdash	Countersink	-	4	gned/off center	<u> </u>	Positioned V		ong stock i diled
		Heat Trea	ıt			Cut Too Short	_	Mislab	-	_	Power Loss/		Other
		Inspection		Tube		Drawing	—	Misrea		<u> </u>	1		1-3
		Marks/Ch	•			Drill Holes	\vdash	Off-set					
		Turning S				Finish	一	4	Calibration		-		
		Wave/Tw				Fit/Function		1	Sequence				

Picklist Print

January-23-14 1:18:16 PM

Work Order ID: 111842

111842

Parent Item:

D3492-11

D3492-11

Parent Item Name: Plug

Start Date: 1/23/14

Required Date: 2/06/14

Page 1

Start Qty: 24.00

Required Qty: 24.00

Comments:

IPP Rev:A 11.04.19 per dwg revC DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.875		Purchased	No		100	f	23.0000	0.04	2			
*M6061T6	SR0 875	*						**				

M6061T6R0 875

6061-T6 Round Bar .875"

Loc Code Location Loc Qty MAT013 23 23 125552

2 JFC 2014-01-30

DQA:			Date:			WORK ORDER NON-CONFORMANCE / UPDATE							
QA Closed:			Date:			WORK ORDER NON-		JINFO	KIVIANCE / UI		Vork Order u	odate only	AEROSPACE
						DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Work Ord	er:					,			a	Г	\neg		- \square
David 8	1					Rework			Skid-tube	Crosstube		Water Jet	Engineering
Part I	۱O.			**		Scrap			Machining	Small Fab	_	d. Eng. Coor.	Quality
NCR I	do.					Use-as-is Suspected Unapproved		merr	noforming Large Fab	Finishing Composite	- Recysio	re/Packaging Supplier	Other
NCN	١٠.				 '	Juspected Oliappioved			raige rab	Composite		20philei [
Root					Desci	ription of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
Design							l						
Doc/Data												!	
Equip/Tooling													
Handling/Pre													
Material													
Operator													
Offset/Setup												İ	
Process													
Supplier							1						
Training Transport													
Unapproved													
опаррточеа			I	<u> </u>			FAI	ULT CA	TEGORY			1	
Landi	ng (Gear				General							
	Ť	Bending			Г	Bend		 Folio/F	Program	Γ	Outside Dim	nensions	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain	J		Over/Under	-	Set-up
	Г	Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	-	Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs	Г	Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/l	Jnclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink	-	1	gned/off center	Γ	Positioned \		
		Heat Trea	it			Cut Too Short		Mislab	eled		Power Loss,	/Surge	Other
		Inspection	n Strip in	Tube		Drawing		Misrea	d	_			
		Marks/Ch	atter			Drill Holes		Off-set					
		Turning S	equence			Finish		Out of	Calibration				
		Wave/Tw	ist in Tub	e		Fit/Function		Out of	Sequence				

DART AEROSPACE LTD	Work Order:	768111
Description: Plug	Part Number:	D3492-11
Inspection Dwg: D3492 Rev: 8 6		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.850	+0.010/-0.001	0.8503	/		MIĈ	JECOZ
Ø0.664	+0.008/-0.001	0.6643	V		ruc	Jte-01
0.045	+0.000/-0.002	0.044	~		CAL	\(\(\cdot\)
0.090	+0.000/-0.002	0.089	/		PIN+CAL	Shop + calipertro
0.500	+/-0.010	0.500	✓		Hb	31006
0.060	+/-0.005	0.060	~		Caliper	Jeco1
0.060	+/-0.005	0, 060	✓		Caliper	11
0.050 x 20°	+/-0.010 x 0.5°	0.080	~		depthb	3tc-07
					20. ph	
<u> </u>						

Measured by: JFC	Audited by:	7	Preliminary Approval:	
Date: 2014-01-30	Date:	14-1-30	Date:	

Rev	Date	Change		 Revise	d by	Appr	roved
Α	08.02.28	New Issue	P/O D3492-049	KJ/DD	10		7 1
В	11.06.21	Dwg Rev updated		KJ	H	77	M
				 	177	7	7

DQA:			Date:											
						WORK ORDER NON	-CC	ONFO	RMANCE / U					AEROSPACE
QA Closed:			Date:								Work Order	update only		
Work Orde	r:					DISPOSITION				NT/PROCESS				
	-					Rework]		Skid-tube	Crosstube		Water Jet Engine		
Part N	lo.					Scrap	1		Machining	Small Fab	F	rod. Eng. Coor.	Quality	
	-					Use-as-is	1		noforming	Finishing	_	tore/Packaging		Other
NCR N	lo.					Suspected Unapproved			Large Fab	Composite		Supplier		
										-				
Root					Desc	ription of work order update		Initial	Ad	ction	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	<u>n</u>	QC Inspector
Design	_	ı												
Doc/Data														
Equip/Tooling														
Handling/Pre	_													
Material											İ			
Operator														
Offset/Setup	_		!								-			
Process	\dashv													
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Transport			ļ						i					
Unapproved			l	L	1		ΕΛ	IIIT CA	L ΓEGORY			<u> </u>		
Landir	10 (iear			·	General		OLI CA	ILGONI	·				
		Bending			Г	Bend	Г	l _{Folio/F}	rogram	J	Outside I	imensions		Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route	一	Grain			_	ler tolerance		Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Inco			Temperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		4	ion Incomplete/L	Jngualified	Part Lost	'Missing		Weld
		Cuffs		-		Contamination		- 1 '	tions Incomplete	·	Part Mov	_	Γ	Wrong Stock Pulled
		Crushing				Countersink		4	gned/off center		Positione	d Wrong		
		Heat Trea	it			Cut Too Short		Mislab	eled		Power Lo	ss/Surge		Other
	Inspection Strip in Tube					Drawing		Misrea	d					
		Marks/Ch	atter			Drill Holes		Off-set						
		Turning S	equence			Finish		Out of	Calibration					
		Wave/Twist in Tube				Fit/Function		Out of	Sequence					

D3492-XX PLUG (SEE TABLE)--NAS1611 O-RING (SEE TABLE)

111842 MC3 1401-23

D3492-XXX PLUG PARTS LIST

	D3432-AAA FEUG FARTS LIST												
QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	QTY -055	PART NUMBER	DESCRIPTION	7			
X								D3492-041	PLUG ASSEMBLY	7			
	х							D3492-043	PLUG ASSEMBLY	7			
	i	Х						D3492-045	PLUG ASSEMBLY				
			X	i _				D3492-047	PLUG ASSEMBLY				
				X				D3492-049	PLUG ASSEMBLY				
					X			D3492-051	PLUG ASSEMBLY				
						X		D3492-053	PLUG ASSEMBLY	Ι.			
							Х	D3492-055	PLUG ASSEMBLY				
1						<u> </u>		D3492-1	PLUG				
	1					l		D3492-3	PLUG				
		. 1						D3492-5	PLUG				
			1					D3492-7	PLUG				
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					1			D3492-11	PLUG				
						1		D3492-13	PLUG	7			
							1	D3492-15	PLUG	<u>]</u> 🖳			
		1						NAS1611-005	O-RING	4			
								NAS1611-005		\dashv			
			1	ļ <u>.</u>					O-RING				
1								NAS1611-010	O-RING	-			
						1		NAS1611-012	O-RING	_			
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					1		1	NAS1611-015	O-RING				
				1				NAS1611-016	O-RING				

 $\frac{\text{NOTES:}}{1) \text{ O-RING:}}$ POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

E	ADD -055 PLUG ASSY & -15 PLUG	AP	13.08.08
D	INCORPORATED DEO D3492-C-1, SHT 2 DIM C FOR -1 WAS 0.055. (SEE CAR11-048)	AJS	11.05.24
¢	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
В	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
Α	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE

DESIGN	PH	DART AEROSPACE LTD						
DRAWN	AP	HAWKESBURY, C	ONTARIO, CANADA					
CHECKED	A55	DRAWING NO.	REV. E					
MFG. APPR.	177	D3492	SHEET 1 OF 2					
APPROVED	143	TITLE	SCALE					
DE APPR.	-#	PLUG	NTS					
DATE 13.0	8.08	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPRISHMENT IN USE SUPPLIES CONTINUE THAT IT IS MOT TO BE USED FOR MAY PURPOSE OR CORPED OR COMMUNICATED TO MAY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART APROPAGE LTD.						

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DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDAT			_	AEROSP	ACE	
QA Closed:			Date:							W	ork Order up	date only			
Work Orde	ır.					DISPOSITION			AC	GAINST DE	PARTMENT	PROCESS			
Work Orde	K Oldel.				_	Rework	1		Skid-tube Cro	osstube	Water Jet Engineering				
Part N	lo.					Scrap			—	nall Fab	Prod. Eng. Coor. Q			\dashv	
	•					Use-as-is			~ —	inishing		e/Packaging	Other		
NCR N	lo.					Suspected Unapproved			~	nposite]	Supplier			
Root					Desc	ription of work order update		nitial	Action		Sign &		1		
Cause	ļ	Date	Step	Qty	D 000	or non-conformance		ief Eng	i e	า	Date	Verification	QC Inspect	or	
Design				Α.,											
Doc/Data															
Equip/Tooling															
Handling/Pre															
Material															
Operator						•									
Offset/Setup															
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Landii						General		1 .	•		7	-			
		Bending			\vdash	Bend	<u> </u>	1	Program	<u> </u>	Outside Dim	F-	Pressure/Forced	d	
		Centre N	ot Concer	ntric		BOM/Route	_	Grain		<u> </u>	Over/Under	<u> </u>	Set-up		
	-	Cracks			\vdash	Broken/Damage/Defect	\vdash	Hardwa			Part Incorred	-	Temperature/Co	ure	
		Crimp/Kii	nk/Ripple	/Wave	\vdash	Burrs	\vdash	1	ion Incomplete/Unqualif		Part Lost/Mi	ssing	Weld		
	-	Cuffs			-	Contamination	<u> </u>	-	tions Incomplete/Unclear	ır 📙	Part Moved	L	Wrong Stock Pu	illed	
	Crushing				<u> </u>	Countersink	-	4	gned/off center	<u> </u>	Positioned V	· ·	¬		
	Heat Treat				<u> </u>	Cut Too Short	<u> </u>	Mislab		<u>L</u>	Power Loss/	Surge	Other		
	Inspection Strip in Tube			Tube	\vdash	Drawing	\vdash	Misrea							
		Marks/Cl			<u> </u>	Drill Holes	-	Off-set							
		Turning S			-	Finish		4	Calibration			·			
	Wave/Twist in Tube					Fit/Function		Out of	Sequence						

0.060±0.005 -- |-ØΒ - 0.090^{+0.000} D C+0.000 0-0.002 CHAMFER 0.050 X 20 DETAIL D -POWDER COAT THESE FACES ONLY PER NOTE 2 - 0.060±0.005 0.500±0.010 - (MASK PRIOR -TO PAINT) D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	В	С	MATERIAL SPEC
D3492-1	0.625	0.394	0.050	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.510	0.045	M6061T6R0.750
D3492-15	0.850	0.640	0.050	M6061T6R0.875

NOTES:
1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
2) FINISH: CHÉMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED 4) UNITS: INCHES UNLESS OTHERWISE NOTED 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: N/A 7) WEIGHT: N/A

DESIGN	PH	DART AEROSPACE LTD						
DRAWN	AP	HAWKESBURY, ONTA	ARIO, CANADA					
CHECKED	A55	DRAWING NO.	REV. E					
MFG. APPR.	77	D3492	SHEET 2 OF 2					
APPROVED	10	TITLE	SCALE					
DE APPR.		PLUG	4:1					
DATE 13.0	80.80	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND COMPOSITION AND IS EXPRISED ON THE COPYRESS COMMITTION THAT IT IS NOT TO BE USED FOR ANY PARFOCK OR CONTED ON COMMISCRED TO ANY PORT OF PRIVATE ANY PARFOCK PRIVATE AND ANY ANY PARFOCK PRIVATE AND ANY ANY ANY PARFOCK PRIVATE AND ANY ANY ANY PARFOCK PRIVATE AND ANY ANY ANY ANY ANY ANY ANY ANY ANY ANY						

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В

DQA:			Date:			WORK ORDER NON-	DART							
QA Closed:			Date:			WORK ORDER HOR			MINIMICE / O		/ork Order up	date only	AEROSPACE	
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT,	ARTMENT/PROCESS		
Part No						Rework Scrap Use-as-is Suspected Unapproved Rework Skid-tube Machining Thermoforming Large Fab Crosstube Small Fab Thermoforming Composite		Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier		Engineering Quality Other				
Root					Desc	ription of work order update	ı	nitial	Act	tion	Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector	
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved														
						<u></u>	FA	ULT CA	TEGORY					
Landi	Bending Centre Not Concentric Cracks Crimp/Kink/Ripple/Wave Cuffs Crushing Heat Treat Inspection Strip in Tube Marks/Chatter Turning Sequence					General Bend BOM/Route Broken/Damage/Defect Burrs Contamination Countersink Cut Too Short Drawing Drill Holes Finish		Grain Hardwa Inspect Instruct Misalia Mislaba Misrea Off-set	ion Incomplete/U tions Incomplete/ gned/off center eled d	<u> </u>	Outside Dimensions Over/Under tolerance Part Incorrect Part Lost/Missing Part Moved Positioned Wrong Power Loss/Surge Pressure/Force Set-up Temperature/C Weld Wrong Stock Pt Other			
		Wave/Twist in Tube				Fit/Function		Out of	Sequence				·	